

5/04

DART AEROSPACE LTD	Work Order:	22071
Description: Stud	Part Number:	D3059-1
Dwg: D3059 Rev. A1	Qty:	20
04.12.08 <i>kg</i> 04.12.08 <i>CP</i>		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	<i>kg</i>	04.12.08	20 20
2	MC	Turn blank as per Folio FA400 and Dwg D3059 Material: AISI 4130N Bar per MIL-S-6758 or AMS 6348/ 6370/ 6528 Ø0.750" (M4130N-R0.750) Batch <i>M15619</i> Threads per MIL-S-7742 Identify for D3059-1	<i>gml</i>	05/01/13	20
3	MV	Cut groove as per Folio FA400 and Dwg D3059 Identify as D3059-1	<i>gml</i>	05/02/17	20
4	MV	Deburr and Tumble for 5 minutes maximum a short time to prevent damage to threads. 04.06.21	<i>gml</i>	05/02/17	20
5	QC2	Inspect parts as they come off the CNC machine	<i>gml</i>	05/01/13	20
6	QC8	Second check	<i>PE</i>	05.02.17	20
7	PG	Issue P/O: <u>2007600</u> Finish: Cadmium plate per QQ-P-416F Class 1, Type II Material release note is required.	<i>U</i>	05-02-21	20
8	RG	Receive and Inspect for transit damage Ensure that material release note is attached	<i>CL</i>	05/02/01	20
9	ST	Identify and Stock	<i>CL</i>	05/03/02	20
10	AC	Cost / part: <u>12.31</u>	<i>SUC</i>	05-03-03	20
11	DC	Close W/O <u>12.71</u> Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	04.03.25	New issue	KJ/RF <i>KE</i>	<i>KE</i>

RELEASED
04.03.25 *KE*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

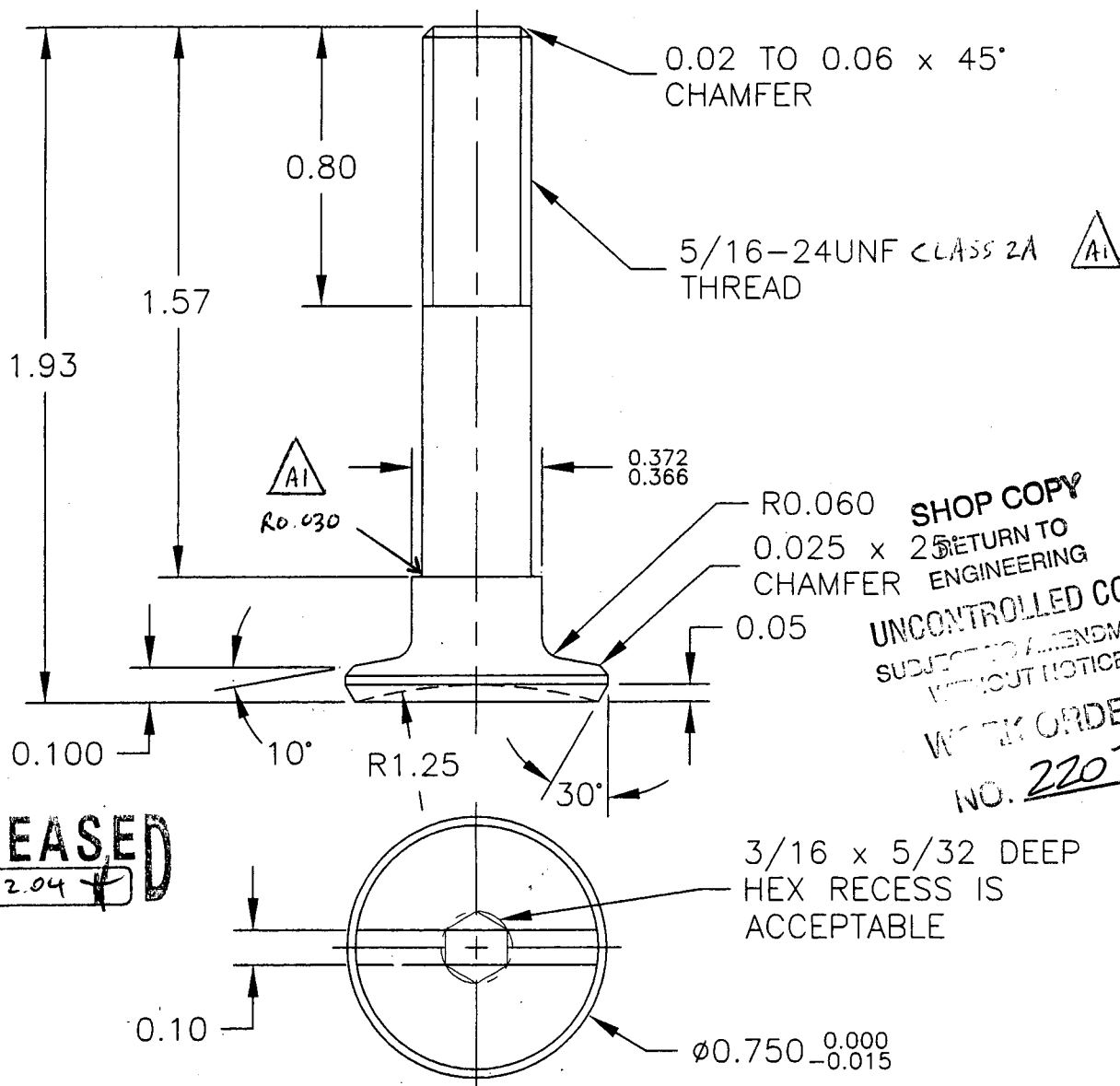
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3059	REV. A SHEET 1 OF 1
DATE 01.11.27		TITLE STUD	SCALE 2:1
A	01.11.27	NEW ISSUE	
A1	#UP 04.04.01	ADD 20.030 + CLASS 2A	



0 SHOP COPY
x 25 RETURN TO
ER ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 22071

RELEASED
01.12.04

D3059-1:

- 1) POSSIBLE SUPPLIER: ANCRA INTERNATIONAL P/N 40110-10
- 2) MATERIAL: AISI 4130N BAR PER MIL-S-6758 OR AMS 6348/6370/6528
MIN TENSILE STRENGTH 180 KSI
- 3) THREADS PER MIL-S-7742
- 4) FINISH: CADMIUM PLATE PER QQ-P-416F CLASS 1, TYPE II
- 5) ALL DIMENSIONS ARE IN INCHES.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 06, 2004
11:09 am

Work Order No : 0022071
Project Name : D3059-1
Project For : WK504
Work Order Type : Main
Main WO Number :
House Part Number : D3059-1
Description : Stud
Manufactured : Yes
Amount Req'd : 5
Amount Done : 0
Start Date : 12-06-04
Est Finish Date : 01-22-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

MANCO
DOMPLEX

8895 Crescent 3
Anjou (Québec) H1J 1B6
Tél.: (514) 355-7867
Fax: (514) 355-8750

ATTN: LINDA LACETTE 2 pages

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

1311

Dart Aerospace LTD

Client / Customer

D3059-1 / D3059-1

de la pièce / part

124467

Votre # de commande / Your purchase order #

90622

Notre # de bon de livraison / Our packing slip #

Inspecteur / Inspector	Renault	Date, équipe / Date, shift	Feb 28 2005
Placage / Plating	QQP416F C485 / T/P/22 carbon		
Quantité totale / Total quantity	40	Quantité inspectée / Inspected quantity	40
Adhésion / Adhesion	Good.		
Épaisseur / Thickness	L.C.D.	H.C.D.	Moy. / avr. 0.0005
Coussures, taches / Leach, spots	non	Rugosité / Roughness	non
Quantité approuvée / Approved quantity	40	Quantité rejetée / Rejected quantity	

Commentaires / Comments

Nous certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Signé au nom de
Signed on behalf of

MANCO
DOMPLEX